

Sooner

Work Order ID 71100



Wednesday, June 22, 2011 1:37:53 PM

Page 1

Item ID: D3609-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 6/22/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *mf*Date: *11-06-23*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3609

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

304.030

1-Cut as per Dwg D3609

Dwg Rev: *E*Prog Rev: *E*

2-Deburr if necessary

B 11-6-23

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 11-6-23

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*8/16/23**P2**sch*

Work Order ID 71100

Wednesday, June 22, 2011 1:37:53 PM

Page 2

Item ID: D3609-1

Accept

Revision ID:

Item Name: Doubler

Start Date: 6/22/2011 Start Qty: 2.00

Required Date: 6/23/2011 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

121



Brake NC

Brake NC

Form as per dwg

Memo

USE DT9760 TOOL

0.00

0.00

SB 11/06/23

(4)

122



Small Fab

Small Fab

Form as per dwg

Memo

1- TRIM AS PER DWG USING GUIDE LINES

0.00

0.00

SP 11/06/23

(4)

123



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

S 11/06/23

(4)

(4)

Pho →

Dart Aerospace Ltd

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3609-1 PAR #: N/A Fault Category: Design / Eng NCR: Yes No DQA: 11 Date: 11.07.06
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 11/09/06 Date: 11/09/06

NCR: <u>71100</u>			WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/06/23	# 122	two Qty x2 Parts scrap 0.530 Lip Bend is in the wrong orientation R.C. Part is not drawn / Program correctly. The Flat Pattern	<u>11.06.23</u>	Scrap + Destroy qty x2. (The two parts are the opposite Ends of Flat Pattern D3609-1 Z).	<u>11.06.27</u>	<u>11/06/27</u>	<u>11.06.23</u>	<u>11/06/23</u>
			<u>11.06.28</u>	Redesign the Part / Drawing correctly. DRAWING / TOOLING CURRENTLY BEING REVISED.	<u>11.06.28</u>	<u>11.06.28</u> by RF	<u>11.06.28</u>	<u>11/06/28</u>

NOTE: Date & initial all entries

Work Order ID 71100

Wednesday, June 22, 2011 1:37:53 PM



Page 3

Item ID: D3609-1

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 6/22/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

Eric C.

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

USE DT9760 TOOL

*Eng 2106 June
mf
11-06-23*

Picklist Print

Wednesday, June 22, 2011 1:37:44 PM

Page 1

Work Order ID: 71100



Parent Item: D3609-1



Parent Item Name: Doubler

Start Date: 6/22/2011

Required Date: 6/23/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-03-26 JLM
IPP Rev:B 08-12-11 as per ECN08-577 DD verified by:EC IPP REV:C
AS PER REV C JLM 11-05-04 VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S22GA

Purchased

No

100

sf

56.5600

1.1769

2.477684



304/316 .032 Sheet

B 11-6-23

Location

Loc Qty

Loc Code

020

7

109057

7

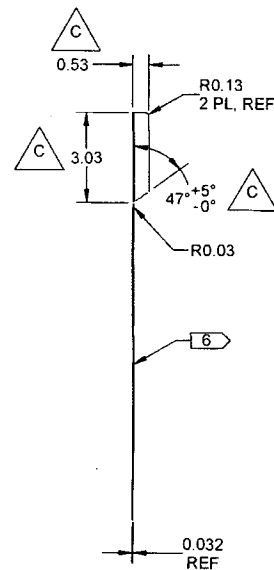
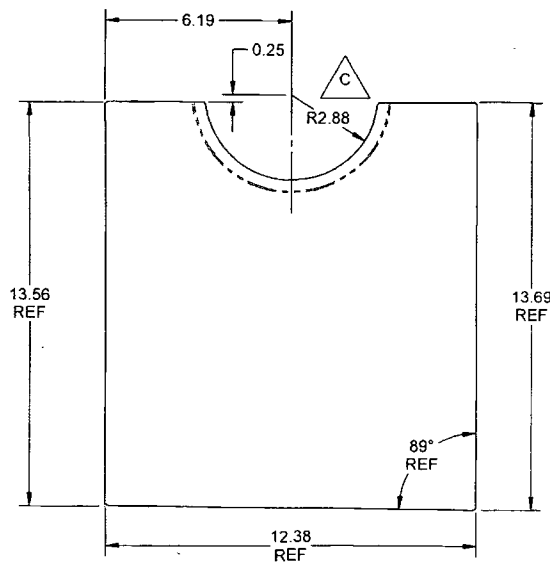
MAT020

49.56

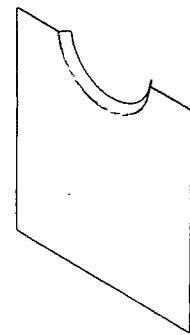
117379

49.56

117379



#71100



D3609-1 DOUBLER

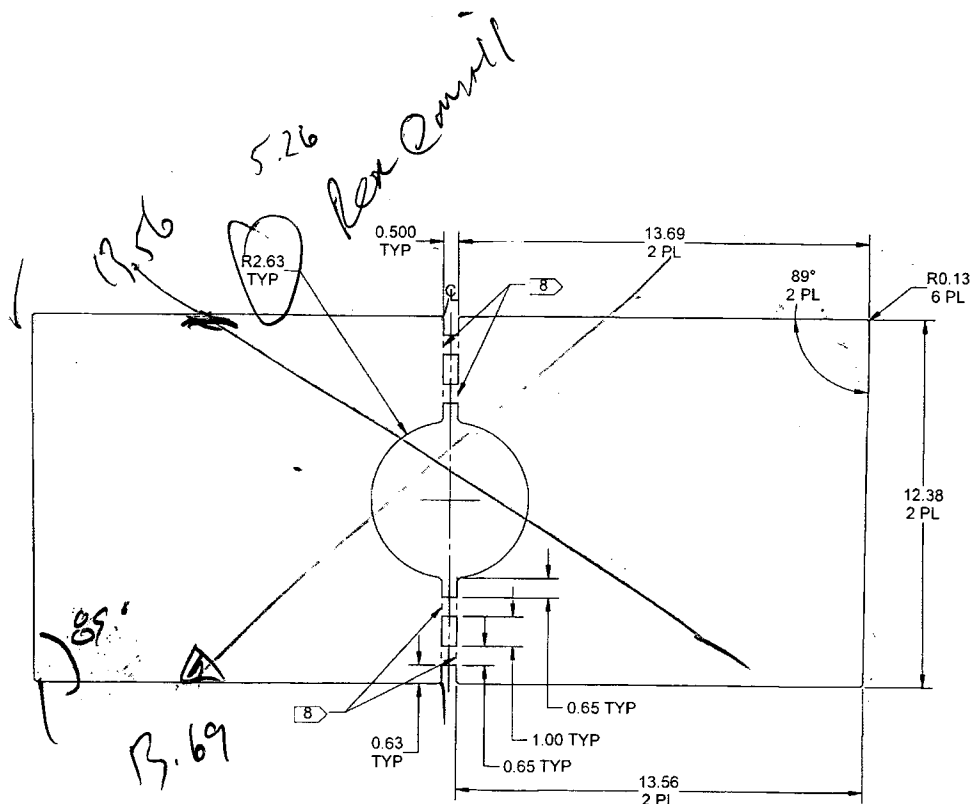
NOTES:

- 1) MATERIAL: MAKE FROM D3609-1F FLAT PATTERN
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.46 lbs
- 8) FORM USING DT9763 AND TRIM PER PHANTOM LINE ON SHEET 2

RELEASED
2011-06-16

REV.	DESCRIPTION	BY	DATE
C	2.88 WAS 2.98 (ZN C5-1); 3.03 WAS 3.20 (ZN C4-1); 0.53 WAS 0.50 (ZN D4-1); ADD ANGLE TOLERANCE (ZNC3-1); REVISE D3609-1F	RF	11.06.07
B	ADD BEVEL (ZN C3-1); ADD FLAT PATTERN (ZN B4-2)	RF	11.04.28
A	NEW ISSUE	MB	07.04.11
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C	
DRAWN	D3609	SHEET 1 OF 2	
CHECKED	DOUBLER	SCALE	
MFG. APPR.		NTS	
APPROVED			
DE APPR.			
DATE	11.06.07		

COPYRIGHT © 2007 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD



#71100

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 22 GAUGE
 PER MIL-S-5059
 OR AMS 5513 (304)
 OR AMS 5524 (316)
 OR ASTM 240
 OR ASME SA240
 PER DART SPEC M304S22GA

2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 2.95 lbs
 8) FORM USING DT9763 AND TRIM PER PHANTOM LINE

D3609-1F FLAT PATTERN
 (MAKES 2 PARTS)



RELEASED
 2011-06-16

DESIGN		DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3609	REV. C
MFG. APPR.		TITLE DOUBLER	SHEET 2 OF 2
APPROVED			SCALE
DE APPR.			NTS
DATE	11.06.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Eric Charbonneau

From: David Shepherd <dshepherd@dartaero.com>
Sent: June 22, 2011 1:38 AM
To: 'Eric Charbonneau'
Cc: 'Marc Bellavance'; 'Robert Fuentes'
Subject: RE: D3609 panel
Attachments: image001.png

Eric,

I will call you in the morning, but I think R2.63 will have to be increased to R2.75 in the flat pattern to preserve the depth of the bevel after forming.

David

From: Robert Fuentes [mailto:rfuentes@dartaero.com]
Sent: Tuesday, June 21, 2011 12:25 PM
To: 'Eric Charbonneau'
Cc: 'David Shepherd'; Marc Bellavance
Subject: RE: D3609 panel

Hi Eric,

To follow up this conversation this morning, the tool to make D3609 Rev. C no need to be modify, because the change on rev. C reflect the dimension of the outcome of the last time they use the tool to make D3609 with flat pattern making one part, and the new flat pattern making two parts, it is mirror of flat pattern was making one part, therefore the outcome making 2 part will no different after they trim the parts.

Roberto

From: Eric Charbonneau [mailto:echarbonneau@dartaero.com]
Sent: Tuesday, June 21, 2011 9:42 AM
To: Roberto Fuentes
Cc: David Shepherd
Subject: RE: D3609 panel

Roberto I need an answer, we are waiting on this to rework the tool.
Eric

From: Eric Charbonneau [mailto:echarbonneau@dartaero.com]
Sent: June 17, 2011 8:21 AM
To: Roberto Fuentes (rfuentes@dartaero.com); David Shepherd
Subject: D3609 panel

Just want to check, will the diameter on the flat pattern change (R2.63), we rebuilt the tool with weld (lots of it!) and now we are ready to machine it to size so just want to double check.

Eric Charbonneau
Production Engineering Coordinator